

Work Order ID 64272

Page 1

Wednesday, December 01, 2010 11:45:49 A

Item ID: D3826-041

Accept



Setup Start



Revision ID:

Item Name: Rib / Gusset Assembly

Stop



Start Date: 12/1/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/8/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-12-1

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3826	Rev B

100



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together□2- locate D2325 on
rib and weld as per dwg D3826□ A/R ER316 S.S. RodBatch: 1114649

110



QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

130



Packaging

Packaging

Identify as per dwg & Stock Location:

Basket cell

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Picklist Print

Wednesday, December 01, 2010 11:46:00 AM

Page 1

Work Order ID: 64272



Parent Item: D3826-041



Parent Item Name: Rib / Guss et Assembly

Start Date: 12/1/2010

Required Date: 12/8/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2235-1 		Manufactured	No				Each	10.0000	1	6		<i>10/12/08</i>	

Basket Rib

Location	Loc Qty	Loc Code
WA	10	
64109	10	

D3929-041



Gusset Assembly

Manufactured No

1		<i>(6x)</i>
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Location	Loc Qty	Loc Code
WA	5	
63052	5	

D3929-042



Gusset Assembly

Manufactured No

1		<i>(5x)</i>
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B64110 (6x) 10/12/08

D3929-043



Gusset Assembly

Manufactured No

1		<i>(6x)</i>
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B64111 (6x) 10/12/08

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

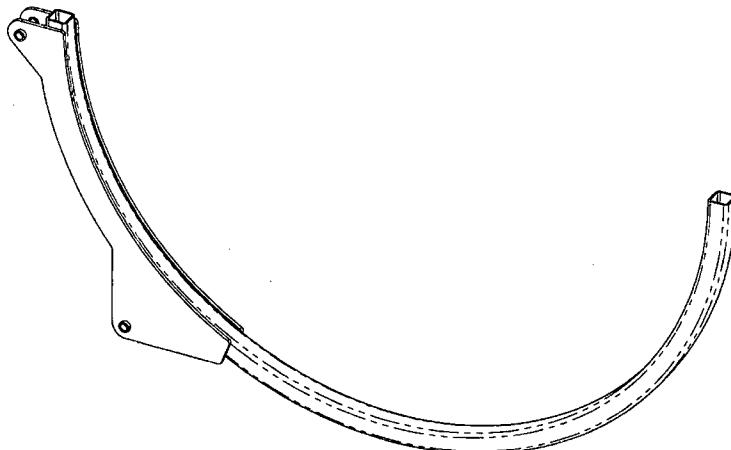
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8 7 6 5 4 3 2 1

ITEM	QTY. .041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

B



D3826-041 RIB/GUSSET ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 640292
BL 10-12-1

RELEASED
8/10/12 AM

B	D3929-041-042 WERE D2325 (ZN D3-1 & ZN D6-2) UPDATED WEIGHT (ZN A8-1) REASON: SEE NCR#09-042.	MB	09.04.16
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	16		
DRAWN	15		
CHECKED	16	DRAWING NO.	REV. B
MFG. APPR.	16	D3826	SHEET 1 OF 2
APPROVED	16	TITLE	SCALE
DE APPR.	16	RIB/GUSSET ASSY	NTS
DATE	09.04.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 3.32 lbs

8 7 6 5 4 3 2 1

3 2 1

1

D

D

C

C

B

B

A

A

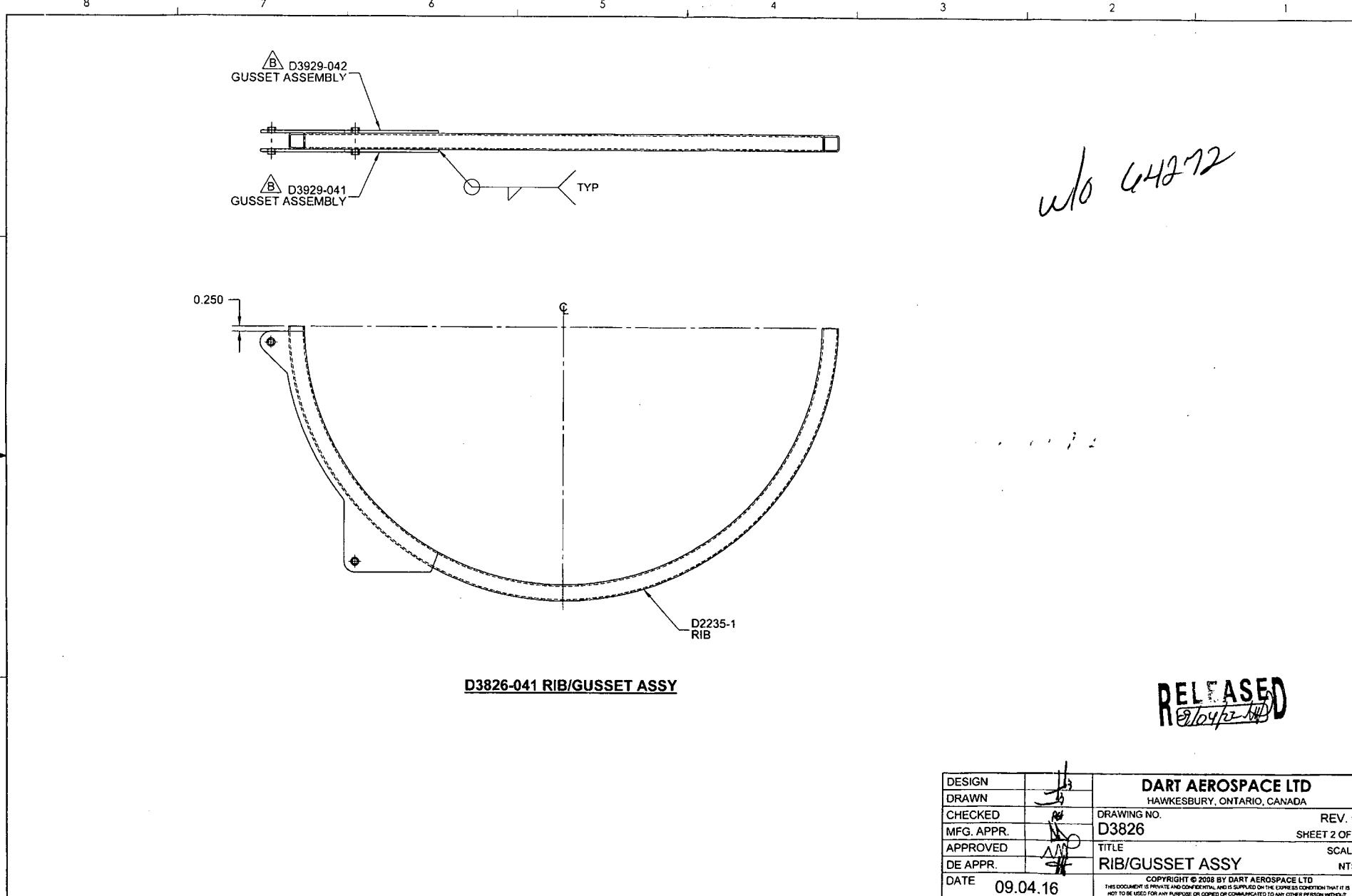
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